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D212-664-201
Job Sheet 197649



Part No: D212-664-201

Job Qty: 1 pcs

Part Name: Aft Crosstube - High



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 7/25/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: IIN-D212-664 REV.J/ D212-664-241 REV E IPP Rev:E 04.02.16 Reformat K/DS IPP Rev:F 06-03-29 Remove
Comments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 08-05-22 up date Qty of rubber
cushion DD ver:EC IPP REV:I 14.05.27 AS PER ECN14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Rework - 1 - Startup	1 pcs	7/25/19		0.00	1.00	Crosstubes - 1		180 19-7-11
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		
110	Rework - 2 - B4B	1 pcs	7/25/19		0.00	1.00	Crosstubes - 1 - B4B		180 19-7-25
							Crosstubes - 2 - B4B		
							Crosstubes - 3 - B4B		
							Crosstubes - 4 - B4B		
120	Rework - 2 - B4B	1 pcs	7/25/19		0.00	1.00	Crosstubes - 1 - B4B		180 19-7-25
							Crosstubes - 2 - B4B		
							Crosstubes - 3 - B4B		
							Crosstubes - 4 - B4B		
230	Crosstubes - 4 - B4B	1 pcs	7/25/19		0.00	1.47	Crosstubes - 1 - B4B		180 19-7-25
							Crosstubes - 2 - B4B		
							Crosstubes - 3 - B4B		
							Crosstubes - 4 - B4B		
240	QC 5	1 pcs	7/25/19		0.00	0.00	QC 5 - 10		180 19-7-25
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

DART AEROSPACE		1270 ABERDEEN ST HAWKESBURY ON, CANADA K6A 1K7 TEL: 1-813-632-5200 FAX: 1-813-632-5246	
PATENT	N/A	CHG	CHG006
P/N	D212-664-201	STC	SH01-9
DESC.	Crosstube High Aft	STC	SR01298NY
LIT	S184746	STC	
MODEL	Bel 204/205/210/212/214/UH-1	STC	
TC APPROVAL # 09-09		MADE IN CANADA	

					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	JUL 29 2019
					QC 5 - 61	DAS 40
					QC 5 - 81	9-89
250	Packaging 1-2 - Pick Kit - B4B 1 pcs	7/25/19	0.00 0.00	Packaging 1 - 1 - B4B		
				Packaging 1 - 2 - B4B		
				Packaging 1 - 3 - B4B		
				Packaging 1 - 4 - B4B		
				Packaging 1 - 5 - B4B		
				Packaging 1 - 6 - B4B		
				Packaging 1 - 7 - B4B		
				Packaging 1 - 8 - B4B		
				Packaging 1 - 9 - B4B		
				Packaging 1 - 10 - B4B		
				Packaging 1 - 11 - B4B		
				Packaging 1 - 12 - B4B		
				Packaging 1 - 13 - B4B		
				Packaging 1 - 14 - B4B		
				Packaging 1 - 15 - B4B		
				Packaging 1 - 16 - B4B		
				Packaging 1 - 17 - B4B		
				Packaging 1 - 18 - B4B		
				Packaging 1 - 19 - B4B		
				Packaging 1 - 20 - B4B		
				Packaging 1 - 21 - B4B		
				Packaging 1 - 22 - B4B		
				Packaging 1 - 23 - B4B		
				Packaging 1 - 24 - B4B		
				Packaging 1 - 25 - B4B		
				Packaging 1 - 26 - B4B		
				Packaging 1 - 27 - B4B		
				Packaging 1 - 28 - B4B		
				Packaging 1 - 29 - B4B		
				Packaging 1 - 30 - B4B		
				Packaging 1 - 31 - B4B		
				Packaging 1 - 32 - B4B		
				Packaging 1 - 33 - B4B		
				Packaging 1 - 34 - B4B		
				Packaging 1 - 35 - B4B		JUL 29 2019
				Packaging 1 - 36 - B4B		
260	QC 4 1 pcs	7/25/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		DAS
				QC 4 - 9		75
				QC 4 - 46		9-89
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
270	Packaging 3-1 - Stock - B4B 1 pcs	7/25/19	0.00 0.00	Packaging 3 - 1 - B4B		JUL 29 2019
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		DAS
				Packaging 3 - 5 - B4B		75
				Packaging 3 - 6 - B4B		9-89
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	7/25/19	0.00 0.00	DC - 1 - B4B	DAG 21 JUL 2 2019
				DC - 2 - B4B	2.00
280 QC 21 - FG	1 pcs	7/25/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	DAG 21 JUL 2 2019

Part Op 230 - (Crosstube) *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, Descriptions: USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-241 and QSI 015 A/R Proseal 890 Batch: 5176610
EXP: 10/19 PROSEAL CURE TIME 72 HOURS: Start: 19-7-25
Finish: 19-7-28 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-241. ***Torque all clamps to 80-100 IN-LBS.***
240 - QC5 (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***
250 - Packaging1-3 (Pick Kit)
260 - QC4 (QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O

270 - Packaging3-1 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D212-664-201 Location : FG098
275 - (Document Control) Photocopy bluefile and create labels as per PPP D212-664-201 CHG006
280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-201	Aft Crosstube - High	1 pcs (1 ea)	100-Rework - 1 - Startup	
D3595-063-530	Rubber Cushion 0.63" Wide X 5.30" Long	4 pcs (4 ea)	230-Crosstubes - 4 - B4B	
MS21920-28	Clamp	4 Ea (4 ea)	230-Crosstubes - 4 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Rework - 1 - Startup	D212-664-201 <u>5184746</u>	①	1	0
230-Crosstubes - 4 - B4B	D3595-063-530	④	27	0
	MS21920-28 <u>5171291</u>	④	120	0

Part Specifications
Specifications could not be found.

Plex 7/11/19 2:27 PM dart.lacelle.linda